Purpose: To provide guidance on the use of metal detectors to detect and enable removal of metal hazards from finished products.

Forms: Forms associated with this policy:
1. Metal Detection Form
2. Extraneous Matter Form

I.   Placement
End use packaging lines shall have a metal detection unit capable of detecting ferrous, non-ferrous and stainless steel metals per local or customer requirements.

II.   Testing
Each metal detection unit shall be checked at start up, at each product changeover, at the end of each product run and at the end of the run if production will not continue in next shift. Additional checks shall be performed every 3 hours if a changeover has not occurred. Customer specific lines may require additional passes with each wand before a metal detection unit is verified as working. In addition, changes to sensitivity or "relearning," of the metal detector must be documented on the metal detector form specific to the detector.

A.   Wand Failure
If a metal detector does not detect a wand then all product(s) going back to the last documented check where all wands were detected shall be placed on hold. This shall be documented on the metal detection form by department head. Maintenance shall be contacted to look at the metal detector and to address the issue. All repairs or adjustments shall be documented on the metal detection form. If a metal detector of the same detectable limit is available then product that would be placed on hold may be run through the secondary metal detector and released. If a secondary metal detector is used it must be documented on the metal detector form.

III.   Alarm
1. During a product run if the alarm sounds and the belt stops the product must be re-run through the metal detector 3 times. Document alarms in the # of alarms column next to the last check.
2. If all 3 passes are negative (no alarms or belt stops) you may continue packaging.
3. If any 1 pass is positive (alarm and belt stop) you must investigate by visual inspection of the product and then sending small portions through the metal detector to isolate the metal.
4. If metal is found an extraneous matter form shall be filled out and QA notified of the finding for investigation.
5. If no metal is found the product shall be repackaged, cased, and palletized.
6. If more than 5 rejected packages of product during 1 hour of run time are found to contain extraneous material, stop the process, place all products produced during the 1 hour run time on Category 2 hold. Notify QA for disposition.

	Wiskerchen Cheese Inc. SOP	
	Title: Metal Detection	# 2.046

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A. Rejected Packages

If greater than 5 rejected packages are found to contain metal per hour then all product(s) going back to the last documented check where all wands were detected shall be re-metal detected.

Process/Program:	Metal Detection		
Hazard Controlled:	Physical		
Limit:	Limit of metal detector/Test pieces size. Greater than 5 rejected packages confirmed to contain metal in one hour of production.		
	Activity:	Responsibility:	Frequency:
Monitoring:	All packages shall pass through an operating metal detector. All rejected packages shall be evaluated to determine the cause of rejection. The product is evaluated by spreading out the product and looking through the material for metal. The number of rejected packages rejected due to confirmed metal shall be recorded.	Trained Operator	Continuous
Records & Location:	Metal Detection Form – QA office Extraneous Matter Form – QA office Hold and Release – QA office Corrective Actions – QA office		
Verification:	1) Passing an appropriate test wand through the opening and confirming detection by alarm activation. 2) Record Review	1) Trained Operator 2) Quality Assurance	1) Startup, Product change over, Every 3 hours, End of run 2) Daily
Process/Program Validation:	1) Record Review 2) Review of customer complaints	SQF Practitioner	Annual
Limit Validation:	Calibration check at limit of detect ability	Service provider under SQF Practitioner's direction	Annually
Corrective Actions:	If the metal detector is not working at its limit, stop the line and replace the metal detector with one of similar sensitivity. Place the product produced since the last time the metal detector was verified to be operating properly on category II hold. Rerun the product through a properly operating metal detector. If more than 5 packages of product are confirmed to contain metal		

	per hour, stop the process and place all product detected during the run time since the last good metal detection check on category II hold. Notify quality assurance to determine the disposition of product on hold. Hold and release documentation is required. Corrective actions must be documented.

Approved By: _____   Date: _____